

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2016-152 Date Opened: 05 Nov 2016 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Cargo Basket Product Model: XL Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket Assembly	JR
70405	4	Lid Walkway Mod.	JR
84240	0	Lid Brace Installation	JR
84255	2	Handle Installation	JR
94027	1	Placard	JR
84261	2	Handle Assembly	JR

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: J. Rekve

ICC / Dual Inspection performed by:

Print: J. Clarke

Work Order closed by:

Print: J. Clarke

Approved Manufacturing Facility 73-04

Sign:

Sign:

Sign:

Form 20.D.03

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

SCA: AD01

SCA: AD02

SCA: AD02

Date: 05-Nov-17 <sup>16</sup> gc.

Date: 05-Jan-17

Date: 05-Jan-17

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0011</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-152</b>
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	<b>Cargo Basket</b>	<b>94010-01</b>	<b>1</b>	<b>94001-66</b>	<b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release</del> <del><input type="checkbox"/> Other regulation specified in block 12.</del> <del>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>05 Jan 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

WEST COAST HELICOPTERS

Work Order: 2016-152Date Opened: 07 Nov 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94010-01	<b>Cargo Basket Assembly</b>	<i>s/w 94001-66</i>	
<b>Step 1</b>				<i>Lid Assembly</i>		
Step 1.a.	. 1		94012-01	Basket Lid Assembly		<i>2016-84</i>
	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	. . 4		CR3213-4-02	Cherry Rivet		<i>15086</i>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>16017</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15086</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		94011-01	Basket Body Assembly		<i>2016-84</i>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		AN960-616	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<i>16030</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>16005</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>16042</i>
<b>Step 4</b>	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2016-37</i>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		



Work Order: \_\_\_\_\_

Date Opened: \_\_\_\_\_

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		See attached
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	2		36275-01	Bushing	Brass, 5/16" Dia	
	2		AN3-12A	Bolt		
	4		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	1		36280-01	Brace Assembly		2016-145
	1		AN3-15A	Bolt		
	1		AN3-17A	Bolt		
	2		AN970-3	Washer		
	3		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 6				Inspection	None	

## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket  
94510, Revision 0 – Extra-Wide Low Mounted Basket  
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket  
76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket  
76410, Revision 3 – Medium Basket (left or right)  
78410, Revision 2 – Long Basket  
94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket  
80310, Revision 0 – Medium Basket  
81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket  
95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-152

Date Open: 07 Nov 2016

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73-04  
01

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using  $\frac{1}{4}$ " piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

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- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

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## 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AD  
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01

- d. Record PO of hinge and rivets on attached material tracking list.

### 4. Install Handle

#### a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

#### b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

#### c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

AD  
73-04  
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### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

AD  
73-04  
02

Technical drawings of the 'Fence' system, showing side and bottom views with callouts for components like mesh, rails, and posts.

DETAIL A  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

DETAIL B  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

4 PLACES

QUICK RELEASE BASKET  
 DESIGNED BY AERO DESIGN LTD.  
 MAXIMUM PERMISSIBLE LOAD  
 300 LBS./136 KG  
 AERO DESIGN LTD.  
 POMER, INDIAN, BC, CANADA  
 www.aerodesign.ca

DETAIL C

SCALE 1 : 1

[illegible]

PART		APPROVALS		DATE		LIST OF MATERIALS	
BASIC CODE REF. HAS 532		DESIGN: R. BARNETT		30 OCT 2011		AERO ESTEER LTD.	
DRAWING NO. 0000000000		CHECKED: E. BURNING				10000 RAILROAD ROAD POWELL, WYOMING 82434 TEL: 800-456-0000 WWW.AEROESTER.COM	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:						EUROCORPER ASS350 & ASS355 SERIES KASSETT, KASSETT, KASSETT, KASSETT BASKET ASSEMBLY (EXTRA LARGE)	
FRACTIONS DECIMALS ANGLES						SCALE: 1" = 1"	
1/16" 0.0150 1/16"						SHEET 1 OF 1	
1/32" 0.0075 1/32"						NO 94010 1	
1/64" 0.0039 1/64"							
3/16" 0.0156 3/16"							
1/2" 0.0156 1/2"							
5/8" 0.0156 5/8"							
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10 1/2" 0.0156 10 1/2"							

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

# NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
"S/N 94001-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"300 LBS/136 KG" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"POWELL RIVER, BC, CANADA" - 0.080 HIGH  
"www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)  
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

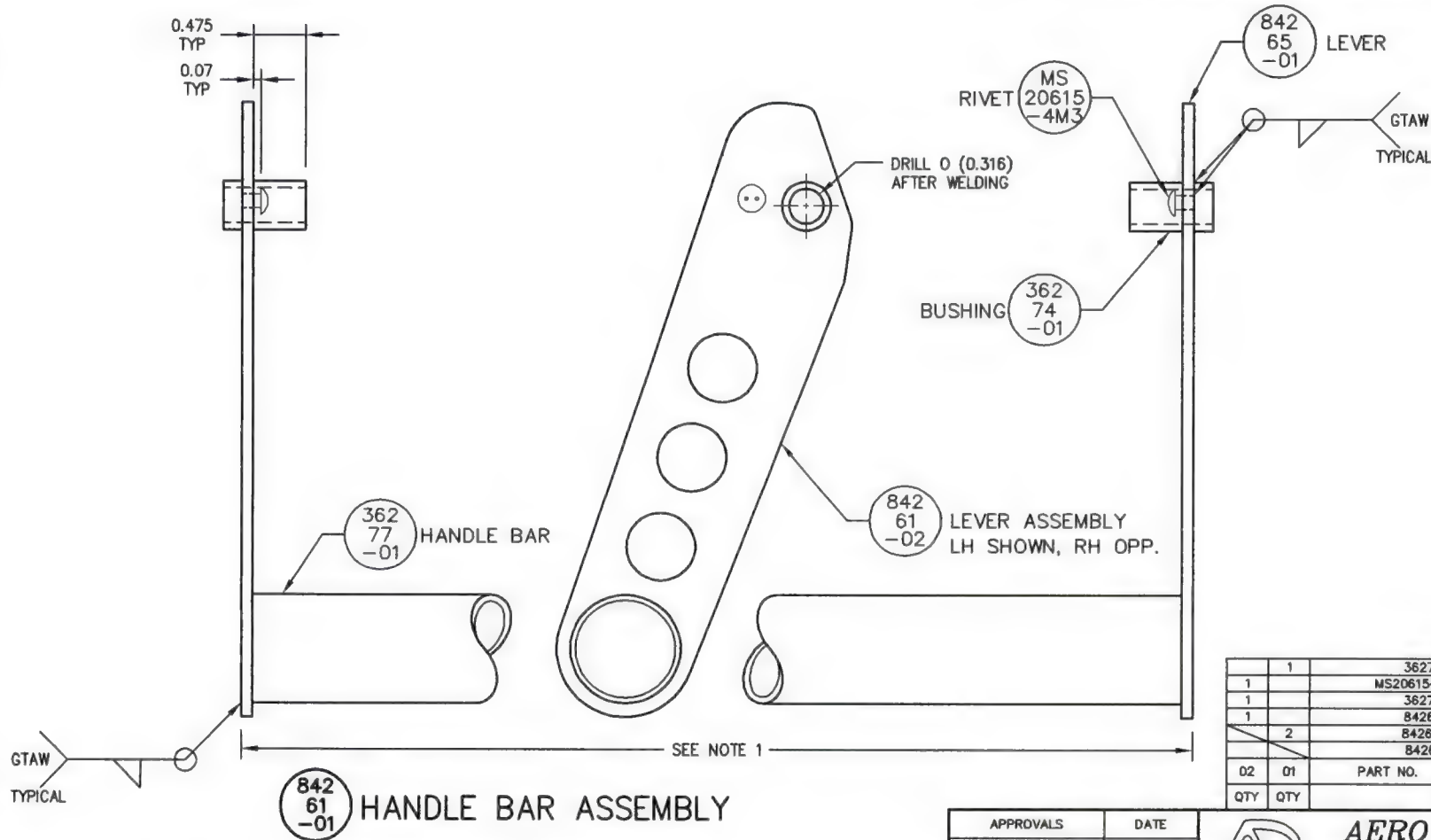
## LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX ±0.010                      ±1/2" X.XX ±0.03 X.X ±0.1					
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>94027</b>	REV. <b>1</b>	



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1		36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

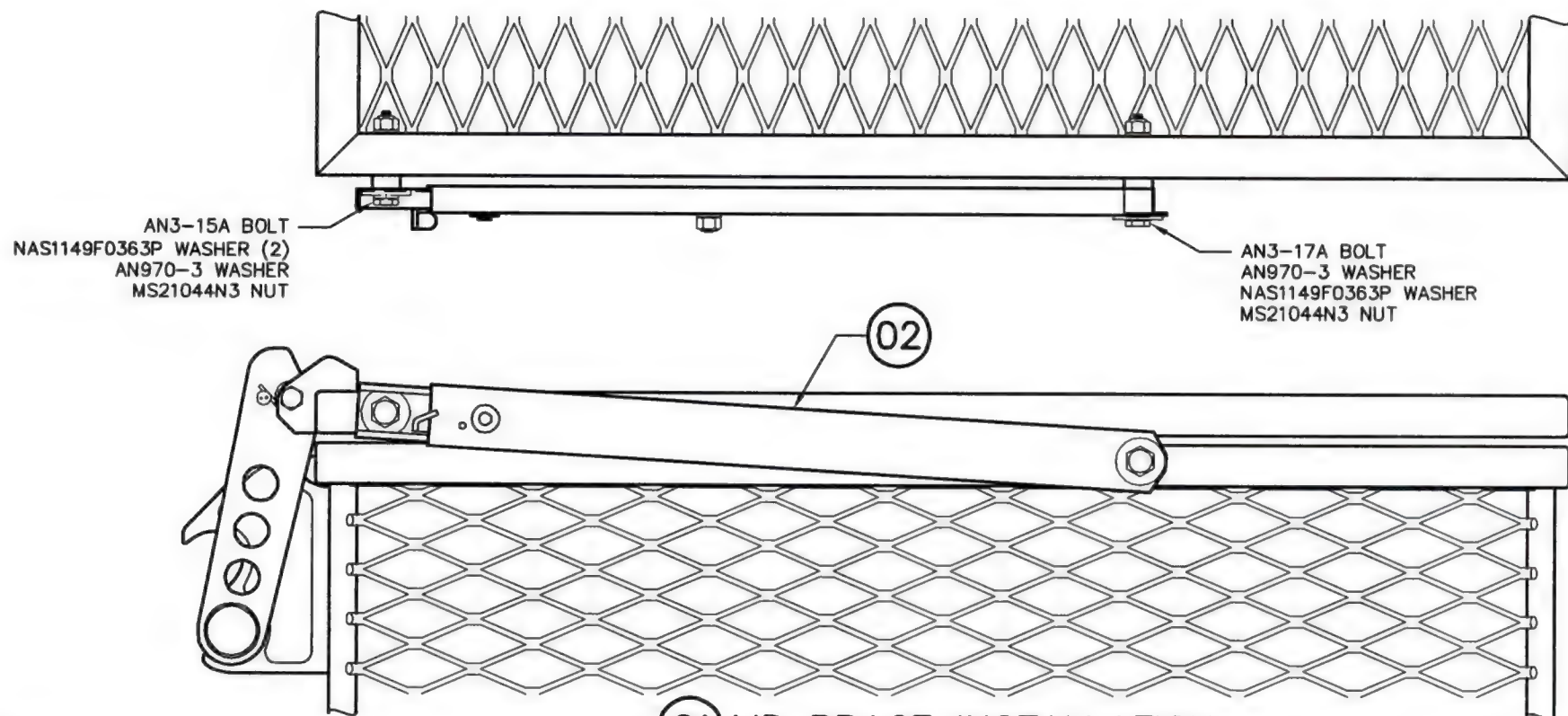
9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.483.8376 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## 01 LID BRACE INSTALLATION

### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT	APPROVALS	DATE	 <div><b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2576      www.aerodesign.ca</div>	<div>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</div> <table><tr><td>NOT TO SCALE</td><td>DWG. SIZE</td><td>DWG. NO.</td><td>REV.</td></tr><tr><td>SHEET 1 OF 1</td><td>A4</td><td>84240</td><td>0</td></tr></table>			NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.	SHEET 1 OF 1	A4	84240	0
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.														
SHEET 1 OF 1	A4	84240	0														
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE	21 MAY 2014												
2	AN970-3		WASHER	CHECKED: JASON REKVE	21 MAY 2014												
1	AN3-17A		BOLT	<div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX ±0.010                      ±1/2" X.XX ±0.03 X.X ±0.1</div>													
1	AN3-15A		BOLT														
1	36280-01	02	LID BRACE ASSEMBLY														
	84240-01	01	LID BRACE INSTALLATION														
01	PART NO.	ITEM	DESCRIPTION														
QTY.	LIST OF MATERIALS																

## Aero Design

### Parts Distribution Sheet

**Description:** Basket Assembly Kit

WO# 2016-152

[illegible]



## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-152

Complete  
(initial or SCA #)

Date Open: 01 Nov 2016

1. Weld Lever Assembly – handle lever jig required  
a. Set MS20615-4M3 monel rivet into socket in jig  
b. Set 36274-01 bushing into socket in jig  
c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.  
d. TIG weld around bushing using ER308L rod.  
e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.  
f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.  
g. Record material POs on attached material list.

PREVIOUSLY  
clw

2. Clean up  
a. Clean lever assembly by media blasting with glass bead.  
b. Drill out lever bushing to O (0.316) on lathe:
  - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
  - ii. Run at 300 RPM.
  - iii. Apply a drop of Rapid-Tap to drill.
- c. De-burr.

AD  
73-04  
07

3. Fabricate Handle Assembly  
a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).  
b. Measure across TOP side of levers.  
c. Cut handle tubing to length measured.
  - i. Handles under 40" long: 1.0" x 0.035 round tube
  - ii. Handles over 40" long: 1.0" x 0.065 round tube
- d. De-burr tube.
- e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
- f. Record material PO on attached material list.

AD  
73-04  
06

4. Weld Handle Assembly  
a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD

5. Clean up  
a. Clean welded area with scotch-brite.

73-04  
07

6. Final Inspection –  
To be completed by a different person than the previous steps.
  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.

AD  
73-04  
07

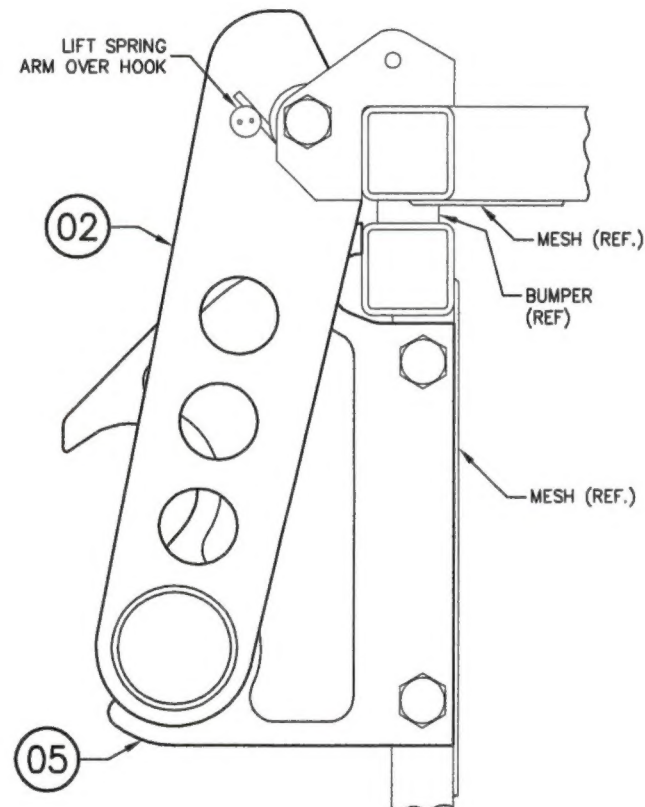
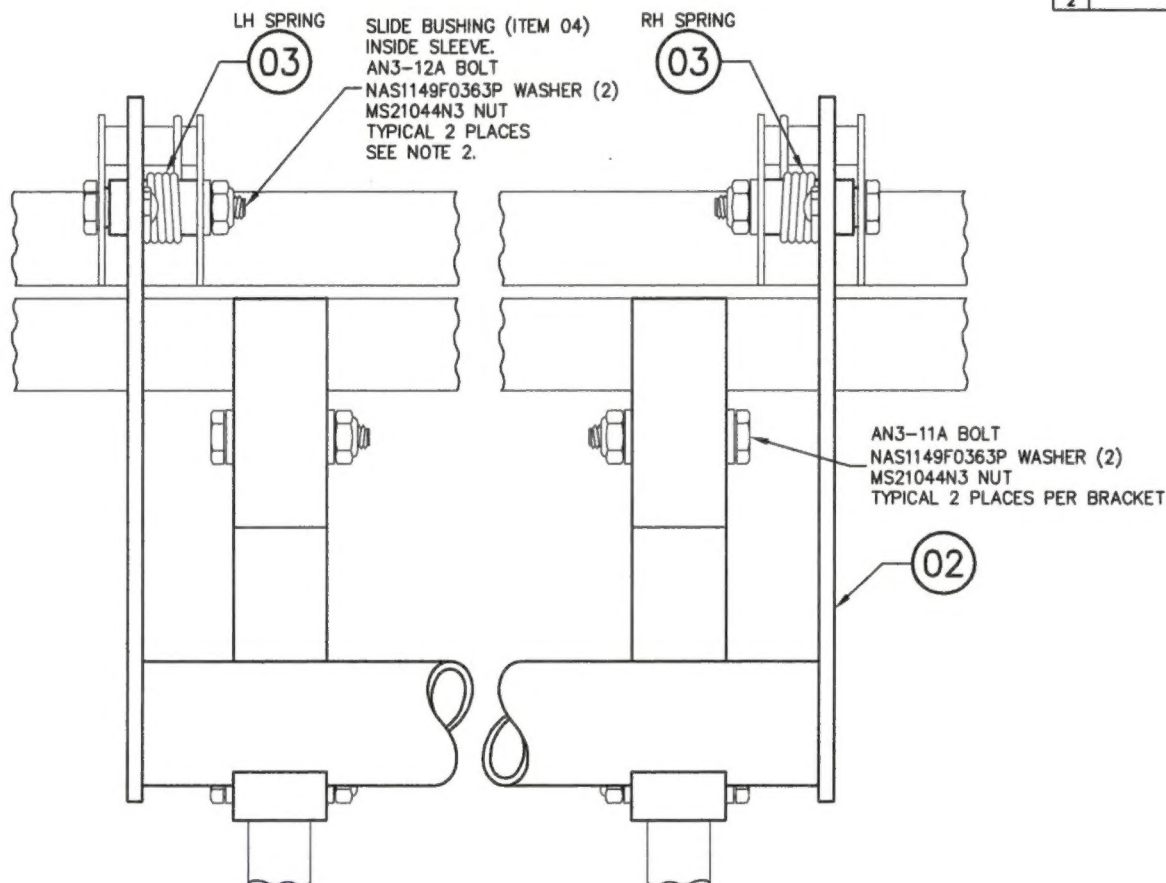
Work Order: 2016-152Date Opened: 07 Nov 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	84261	84261-01	Handle Assembly		
Step 1				Weld Lever Assembly		2015-122
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
Step 2				Clean Up	None	
Step 3				Fabricate Handle Bar		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	15073
Step 4				Weld Handle Assembly	None - Fuse weld, no rod req.	
Step 5				Clean Up	None	
Step 6				Inspection - Final Assembly	None	

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF--81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



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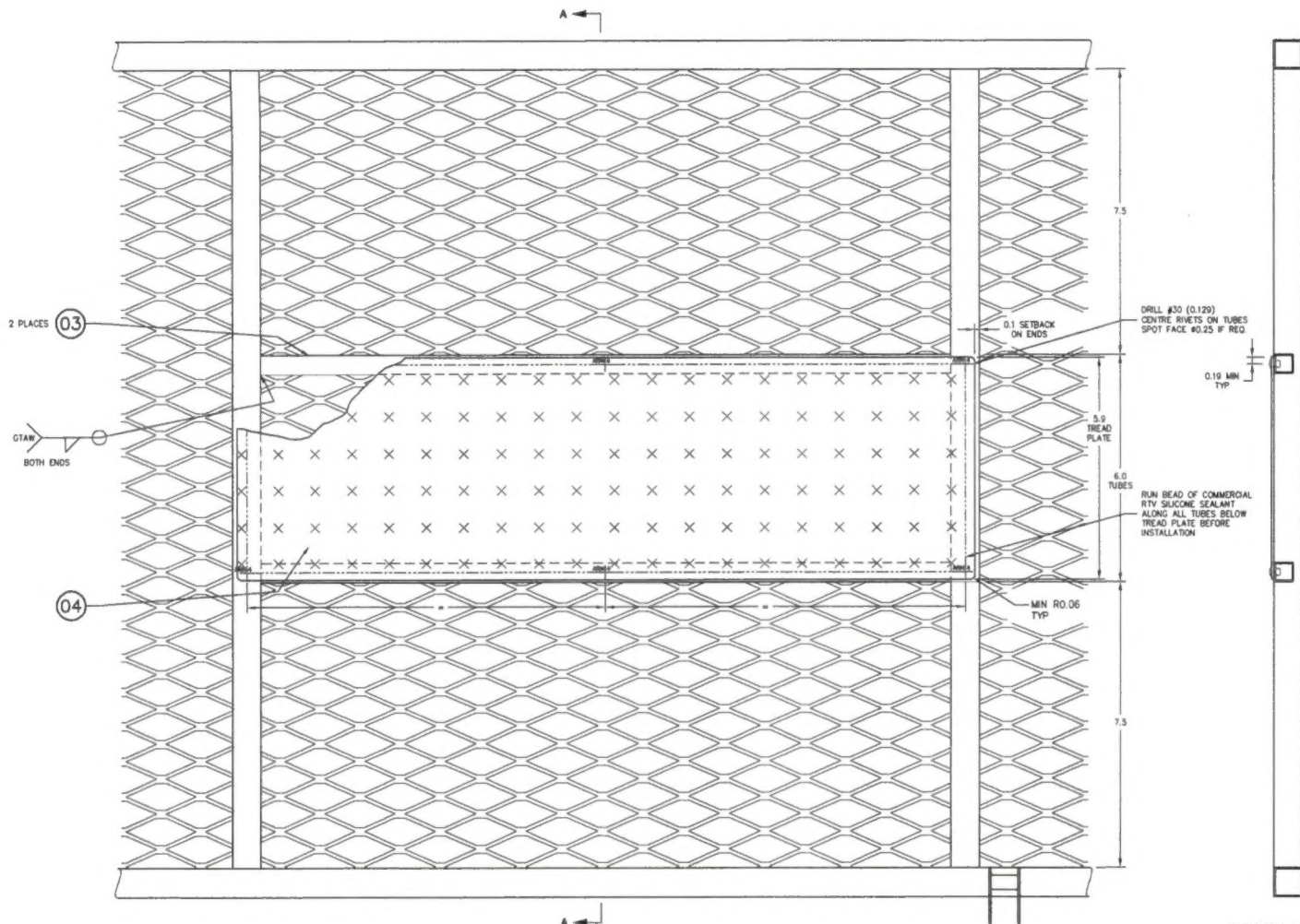
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POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.683.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BUC	MAN 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD500H, BELL 206B BASKETS	BUC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BUC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT RIVET; ADD NOTE 7	BUC	29/05/2014



01 BASKET LID ASSEMBLY

SECTION A-A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM COMMERCIAL	0.063 TREAD PLATE		
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF: HAS 523 C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED BASIC CODES: BJ=MS20470AD BB=MS20426AD ABN=CR3213 ARM=CR3212		DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH + U INSTALL NEW RIVET + U REMOVE/REPLACE RIVET - U EXISTING RIVET		APPROVALS DESIGNED: JEFF CLARKE CHECKED: E. BURGON DATE: 21 SEPT 2006 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 904.480.1376 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1 : 1.5 SHEET 1 OF 1		DWG SIZE A1	
				DWG NO. 70405		REV. 4	